

Work Order ID 113328

March-13-14 8:38:11 AM

113328

Page 1

Item ID: K642-511 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Saddle 642-511
Start Date: 2/12/14 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 2/12/14 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: MCS Date: 14-02-13 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	P								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Create White labels per PPP K642-511	CHG005							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
31
9-89

14-03-17

2x

2

DAS
33
9-89

14-03-14

DAS
31
9-89

14-03-17

2x

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Item ID: K642-511 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle 642-511
 Start Date: 2/12/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 2/12/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130	Packaging	0.00							
Packaging	Memo								
Packaging	Identify and pack for shipping as per PPP K642-511								
	Location: PK14								
140	QC21- Final Inspection - Work Order Release	0.00							
140	QC	0.00							
Quality Control	Memo								

2 DAS 06 9-89 MAR 17 2014

PL 14-03-16

4-03-17

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113328

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A07.06.05 new issueEC
IPP Rev.B 08.02.05 , Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-648-013		Manufactured	No			110	Each	7.0000	1	2			DAS 06 9-89
**													

D206-648-013

Ground Handling Wheel Modification

Location

Loc Qty

Loc Code

PKG013

7

108084

3

110290

1

112884

3

D2932-1

Manufactured No

110

Each

17.0000

1

2

**

DAS
33
9-89

14-03-14

D2932-1

206 Saddle Left Side

DAS
31
9-89

Location

Loc Qty

Loc Code

ST437

17

107966

1

109162

7

112271

1

113054

6

88413

1

98161

1

113054

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Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

D2933-1

Manufactured No

110

Each

17.0000

1 1 2
**

DAS
33
9-89

DAS
06
9-89

D2933-1

206 Saddle Left

DAS
31
9-89

Location

Loc Qty

Loc Code

ST437

10

108888

2

109165

4

112551

4

ST438

6

113216

6

ST446A

1

98159

1

108888

DAS
06
9-89

D2938-1

Manufactured No

110

Each

20.0000

1 1 2
**

DAS
33
9-89

14-03-14

D2938-1

206 Saddle Left Side

DAS
31
9-89

Location

Loc Qty

Loc Code

ST438

11

107691

1

108897

2

113227

4

113838

4

ST447

9

106453

2

109164

6

98163

1

113227

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Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

D2939-1

Manufactured No

110

Each

20.0000

1 2

D2939-1

206 Saddle Left Side

DAS
31
9-89

Location

Loc Qty

ST438

19

109168

4

112275

5

113056

6

113617

4

ST447

1

98165

1

Loc Code

**

DAS
33
9-89

AN3C41A

Purchased

No

110

Each

180.0000

8 16

AN3C41A

Bolt

DAS
31
9-89

Location

Loc Qty

FG

10

103324

4

122843

6

ST353

170

m127544

1

m128319

169

Loc Code

**

DAS
33
9-89

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Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

D2652

Manufactured No

110 Each

1,231.000 16 32

D2652

Bushing

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

FG	44
31985	44
ST014	1187
103022	50
103643	201
110800	200
113196	400
113796	336

Loc Code

MS21043-3

Purchased No

110 Each

1,262.000 20 40

MS21043-3

Nut

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

FG	80
103691	80
ST315	182
124555	43
m126741	139
ST509	1000
m128398	1000

Loc Code

18x126741

22x128398

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113328

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

D3672-7

Manufactured No

110 Each

1,373.000

24 48

D3672-7

Phenolic Washer

**

DAS

33
9-89

DAS
31
9-89

Location

Loc Qty

FG	25
93370	25
ST060	1348
103641	541
111568	307
113195	500

Loc Code

111568

AN5C11A

Purchased No

110 Each

265.0000

8 16

AN5C11A

Bolt

**

DAS

33
9-89

DAS
31
9-89

Location

Loc Qty

FG	4
103715	4
ST362	177
M127933	27
M128403	150
st503	84
M126105	49
M127817	35

Loc Code

127933

AN5C12A

Purchased No

110 Each

67.0000

4 8

AN5C12A

BOLT

**

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

FG	2
18918	2
ST362	65
M127290	15
M127815	50

Loc Code

7x127290
1x127815

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Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

AN5C13A Purchased No 110 Each 163.0000 4 8

2x *AN5C13A*

BOLT

DAS
31
9-89

Location

Loc Qty

Loc Code

ST362	38
120562	38
st503	75
M127363	75
ST516	50
M126105	50

**

DAS
33
9-89

120562

NAS1149C0532R Purchased No 110 Each 360.0000 8 16

2x *NAS1149C0532R*

WASHER

DAS
31
9-89

Location

Loc Qty

Loc Code

GA	55
116513	55
ST292	305
m126319	305

**

DAS
33
9-89

126319

AN4C6A Purchased No 110 Each 981.0000 12 24

2x *AN4C6A*

Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	14
103344	4
121657	10
ST355	667
m125709	167
m128324	500
ST517C	300
m128403	300

**

DAS
33
9-89

14-03-14

125709

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K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

D3672-3

Manufactured No

110

Each

1,803.000

24 148

DAS

33

9-89

D3672-3

Phenolic Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	111	
84432	11	
89273	100	
FP001	63	
107316	63	
ST060	1628	
110251	128	
112455	500	
113746	1000	
ST061	1	
93925	1	

24-110251

NAS1149C0432R

Purchased

No

110

Each

4,716.000

24 48

DAS

33

9-89

NAS1149C0432R

WASHER

DAS
31
9-89

Location

Loc Qty

Loc Code

GA	1959	
m125807	1959	
ST292	92	
119124	6	
121255	7	
122441	79	
ST510a	2665	
m126221	2665	

126221

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Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

110

Each

1,658.000

13 26

MS21043-4

Nut

DAS

33

9-89

Location

Loc Qty

Loc Code

FG	40	
104603	40	
GA	33	
125807	33	
ST315	512	
m123021	12	
m128429	500	128429
ST509	1073	
m127255	73	
m128300	1000	

DAS
31
9-89

D3407-043

Manufactured

No

110

Each

13.0000

1 2

D3407-043

Tow Ring

DAS

33

9-89

Location

Loc Qty

Loc Code

ST446	4	
103303	4	
ST463	9	
106890	2	
108105	2	
112541	5	112541

DAS
31
9-89

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113328

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

D3456-1

Manufactured No

110

Each

194.0000

1 2

DAS

33

9-89



2x ***D3456-1***

Washer

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST046

187

107629

1

111782

100

113126

86

113126

D2712

Manufactured No

110

Each

875.0000

10

1 20

DAS

33

9-89



2x ***D2712***

Set Screw

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

825

101775

55

107365

2

~~108809~~

18

110809

150

112534

100

113205

200

113809

300

~~110809~~
110809

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Work Order ID: 113328

113328

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

D3457-1

Manufactured No

110

Each

51.0000

2 4

2x ***D3457-1***

Washer

**

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

10

32409

10

ST046

41

109133

16

83268

2

99638

23

109133

D2934

Manufactured No

110

Each

36.0000

2 4

2x ***D2934***

Saddle Spacer

**

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

6

31929

6

ST021

30

106671

4

108742

2

112252

24

2x106671

2x112252

D2935

Manufactured No

110

Each

21.0000

2 4

2x ***D2935***

Saddle Spacer

**

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

6

31793

6

ST021

15

111577

15

111577

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Work Order ID: 113328

113328

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

AN3C36A

Purchased

No

110

Each

256.0000

9 18

DAS

33

9-89

AN3C36A

Bolt

**

Location

Loc Qty

Loc Code

FG

25

101261

4

122204

11

124827

10

ST514

231

m127769

81

m128398

150

127769

AN3C35A

Purchased

No

110

Each

92.0000

3 6

DAS

33

9-89

AN3C35A

Bolt

**

Location

Loc Qty

Loc Code

FG

4

18914

4

ST352

88

M125958

3

M127745

25

M127746

35

M128398

25

127745

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Work Order ID: 113328

113328

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0332R

Purchased

No

110

Each

6,712.000

24

48

NAS1149C0332R

WASHER

DAS
33
9-89

Location

Loc Qty

Loc Code

GA

1089

125654

1089

st510

5623

m126319

61

m127306

2500

m127410

3000

m127831

62

127410

D3396-3

Manufactured

No

110

Each

77.0000

2

4

D3396-3

Bushings

DAS
33
9-89

Location

Loc Qty

Loc Code

FG

10

26772

10

ST041

67

109098

67

109098

D3672-1

Manufactured

No

110

Each

1,658.000

24

48

D3672-1

Phenolic Washer

DAS
33
9-89

Location

Loc Qty

Loc Code

FG

10

85222

10

ST060

1648

103845

4

112218

500

113581

500

93886

450

99099

194

93886

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Work Order ID: 113328

113328

Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

AN5C35A Purchased No 110 Each 16.0000

AN5C35A

Bolt

**

DAS

33

9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST338

16

123930

6

M128374

10

123930

AN5C15A Purchased No 110 Each 107.0000

AN5C15A

Bolt

**

DAS

33

9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST337

57

M126180

7

M128429

50

st503

50

M127290

50

126180

AN5C32A Purchased No 110 Each 85.0000

AN5C32A

BOLT

**

DAS

33

9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

4

18918

4

ST337

6

M123930

6

ST504

75

m125842

50

m126007

25

123930

125842

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Parent Item: K642-511

K642-511

Parent Item Name: Saddle 642-511

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

AN5C34A

Purchased

No

110

Each

6.0000

2 4

AN5C34A

Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

4

M126007

4

126007

MS21043-5

Purchased

No

110

Each

195.0000

4 8

MS21043-5

Nut

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

88

116548

88

ST315

87

121584

87

121584

DAS
33
9-89

DAS
33
9-89

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4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4382-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C518L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C8A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET ⁽¹⁾
23A					1	1				D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET ⁽¹⁾
24A					1	1				D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET ⁽¹⁾
25A					1	1				D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET ⁽¹⁾
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3458-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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Revision: P
Date: 13.02.12

REFERENCE ONLY

DART AEROSPACE USA, INC.

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ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN980C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN980C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3673-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: P
Date: 13.02.12

100-111111

Work Order ID 113328

March-13-14 8:38:11 AM

113328

Page 1

Item ID: K642-511

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle 642-511

Start Date: 2/12/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/12/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 14-02-13

Tooling:

Date:

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-642

P

JB

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Create White labels per PPP K642-511 CHG005

MLJ 14-03-14

(Signature)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control